

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014389**Date Inspected:** 25-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Listed below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girders**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

- 1) OBG Lifts 2W/3W - plate E field splice welding
- 2) OBG Lifts 1W2W - plate D stiffener splice grinding and inspection
- 3) OBG Lifts 5W & 6W - prep at Pier 7

1) The QAI observed ABF personnel back welding plate E at OBG lifts 2W/3W field splice. The QAI noted that the overhead position (4G) CJP weld segments C1 and C2 are being completed after the backing bar has been removed. The QAI noted that the Quality Control (QC) Inspector James Cunningham is monitoring this welding. The QAI observed ABF workers Jeremy Dolman, ID 5042 and Rory Hogan, ID 3186, making the welds with gas shielded flux cored arc welding (FCAW-G). The QAI was informed that welding procedure specification (WPS) ABF-WPS-D15-3040A-1 is being used for this welding. The QAI randomly measured the preheat, interpass temperature and welding parameters and noted that they appeared to be conforming to the WPS requirements.

2) The QAI observed ABF personnel grinding and cleaning up the stiffener splice welds in OBG lifts 1W/2W at plate D. The QAI noted that all welding appeared to be finished, the welds were being ground flush and smooth and the weld tabs were being removed from the complete joint penetration (CJP) butt welds. The QAI also observed the QC Inspectors Jesus Cayabyab and Steve McConnell performing non-destructive testing (NDT) on the completed welds. See the attached photo.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

3) The QAI observed ABF activities at the Pier 7 location. The QAI did not observe any Quality Control (QC) Inspectors present. The QAI observed ABF personnel grinding the zinc primer from the field splice weld base metal on OBG lift 6W. The QAI also noted that ABF personnel are welding on barges and other job related equipment. The QAI also noted that the contractor is assembling parts of the temporary trestle on the barges at Pier 7. The QAI did not observe any personnel welding on bridge components.



Summary of Conversations:

The QAI relayed the observations of OBG splice welding to the QAI Danny Reyes. The QAI also generated a shift turn-over report with this information. The QAI relayed the observations at Pier 7 and the general status of work observed to the Lead QAI Bill Levell. The QAI was informed that welder Javier Arvizu, ID 2603, has been informally approved by the Engineer for FCAW-G all positions welding. Except as described above, there were no other notable observations or conversations during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi, (916)813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Croff, Scott	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
